

Work Order ID 63706

November 10, 2010 10:58:10 AM

Page 1

Item ID: D212-725-1-201F

Accept

Revision ID:

Item Name: Doubler

Start Date: 11/10/10 Start Qty: 4.00

Required Date: 11/15/10 Req'd Qty: 4.00

Reference:

Approvals:

Process Plan: *W*

Date:

Tooling:

QC:

Date:

SPC (Y/N):

Cust Item ID:

Customer:

Setup Start

Stop

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

Draw Nbr

Revision Nbr

D212-725-1

D

100

0.00



Waterjet

FLOW CNC Waterjet

Memo

1-Cut as per Dwg

Dwg Rev: *B*

Prog Rev: *B*

2-Deburr if necessary

0.00

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00

B 10-11-11

ES 10/11/15 (4)

10-11-11

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Page 2

Item ID: D212-725-1-201F

Accept

Setup Start

Revision ID:

Stop

Item Name: Doubler

Start Date: 11/10/10 Start Qty: 4.00

Cust Item ID:

Required Date: 11/15/10 Req'd Qty: 4.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

4

11/10/15

130

Bend as per dwg

0.00



Brake NC

Memo

0.00

Brake NC

SB 10/11/14

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

SB 10/11/16

74

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Page 3

Item ID: D212-725-1-201F

Accept



Setup Start



Revision ID:

Stop



Item Name: Doubler

Start Date: 11/10/10 Start Qty: 4.00



Cust Item ID:

Required Date: 11/15/10 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location: 386

0.00



Packaging

Memo

0.00

Packaging

10/11/17

4 8

H 10-11-17

Cecilia/h (4)

Work Order ID 63706

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Page 4

Item ID: D212-725-1-201F

Accept



Setup Start



Revision ID:

Stop



Item Name: Doubler

Start Date: 11/10/10 Start Qty: 4.00



Cust Item ID:

Required Date: 11/15/10 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

OK 10/11/17

10-11-17
(4)

Picklist Print

November 10, 2010 10:58:09 AM

Page 1

Work Order ID: 63706

Parent Item: D212-725-1-201F

Parent Item Name: Doubler



Start Date: 11/10/10

Required Date: 11/15/10

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP revA 10.07.22 new issue EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.032		Purchased	No			100	sf	69.5000	0.0563	0.237053			



2024-T3 .032 sheet



B10-11-11

Location

Loc Qty

Loc Code

MAT22

69.5

105555

3

111699

4

113189

62.5

102189

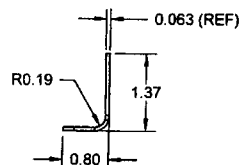
④

D212-785-1-201F

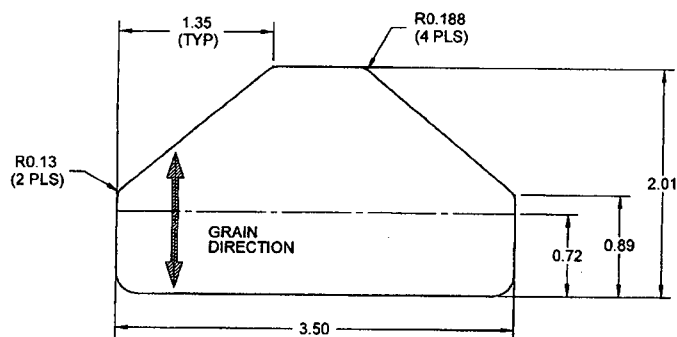
X	First Article	X	Prototype
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Measured by: <i>KB</i>	Audited by: <i>/</i>	Prototype Approval:
Date: <i>10-11-11</i>	Date: <i>10/11/15</i>	Date:

H:\FORMS\Quality Assurance\approved QA\FAI revD



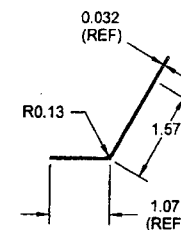
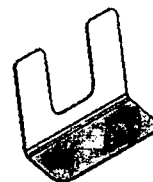
D212-725-1-197 COWL CLIP
(MAKE FROM D212-725-1-197F)



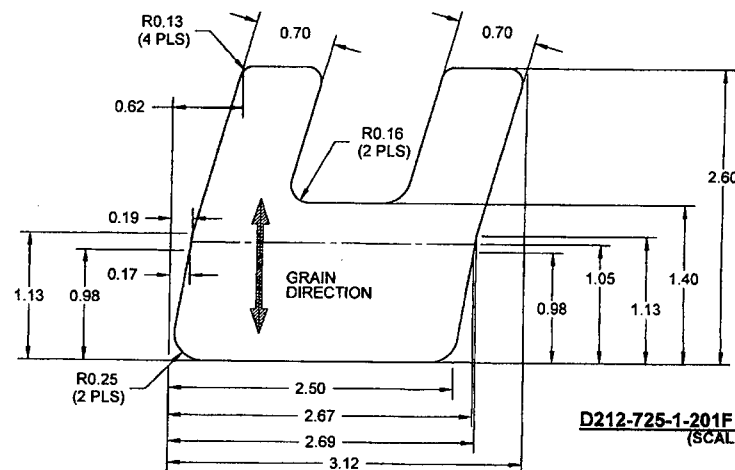
D212-725-1-197F FLAT PATTERN
SCALE 1:1

D212-725-1-197 NOTES:

- 1) MATERIAL: 2024-T3 SHEET 0.063 THICK PER QQ-A-250/4 OR AMS 4037 (REF. DART SPEC. M2024T3S.063)
- 2) FINISH: ACID ETCH, ALODINE 1200 OR 1201 PER MIL-C-5541 AND/OR PRIME PER AIRCRAFT MAINTENANCE MANUAL
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: N/A



D212-725-1-201 DOUBLER
D212-725-1-202 OPPOSITE
(MAKE FROM D212-725-1-201F)



D212-725-1-201F FLAT PATTERN
(SCALE 1:1)

D212-725-1-201-202 NOTES:

- 1) MATERIAL: 2024-T3 SHEET 0.032 THICK PER QQ-A-250/4 OR AMS 4037 (REF. DART SPEC. M2024T3S.032)
- 2) FINISH: ACID ETCH, ALODINE 1200 OR 1201 PER MIL-C-5541 AND/OR PRIME PER AIRCRAFT MAINTENANCE MANUAL
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: N/A

RELEASED
2009-10-28

alob 63706

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	DS	DRAWING NO.	REV. D
MFG. APPR.	N/A	D212-725-1	SHEET 66 OF 67
APPROVED	#	TITLE	SCALE
DE APPR.	#	212S DETAIL PARTS	1:2
DATE	08.03.14	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

L Lacelle

From: Robert Fuentes [rfuentes@dartaero.com]

Sent: November 16, 2010 9:32 AM

To: 'L Lacelle'

Subject: RE: D212-725-1-201

Sorry, the angle 60 degree. Will there in the next 4 digits revision.

Roberto

From: L Lacelle [mailto:llacelle@dartaero.com]

Sent: Tuesday, November 16, 2010 6:27 AM

To: 'Robert Fuentes'

Subject: D212-725-1-201

What angle is required? Degrees?

Thank You,
Linda Lacelle
Production Manager
Dart Aerospace Ltd

11/16/10